

Split Just Today

Work Order ID 70088-



Thursday, May 26, 2011 1:52:29 PM

Item ID: D2680-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate

Start Date: 5/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2680

Rev B1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2680
Debur if necessary

Dwg Rev: B1

Prog Rev: B1 2-

B11-5-25

24

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suloshka

counters
724

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Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Deburr 2-C'sink as per Dwg D2680

ES 5/15/26 (24)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SO 1165/27 (24)

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

3:00

FINISH TIME:

8:05

OVEN TEMPERATURE:

8.45.

24 BL 11-5-27.

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Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

21 0 44 4/05/27

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plate as per Dwg D2680

4/5/05/30 (22)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 4/05/30

cont
(x22)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Identify as per dveg & Stock Location 20

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/2011

11/5/31

11-05-30

Picklist Print

Thursday, May 26, 2011 1:52:26 PM

Page 1

Work Order ID: 70088

Parent Item: D2680-041

Parent Item Name: Nut Plate



Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

170

sf

152.5000

0.0131

0.275789



1010/1025 sheet 16GA



B11-5-26

Location

Loc Qty

Loc Code

MAT019

152.5

116791

34.5

117500

118

116791

24

MS20426AD3-3

Purchased

No

170

Each

2,377.000

2

40



Rivet



Location

Loc Qty

Loc Code

ST316

2377

19099

2377

40

83 11/05/27

MS21069L4

Purchased

No

110

Each

305.0000

1

20



Nutplate



Location

Loc Qty

Loc Code

ST302

305

106285

291

18536

14

10

14

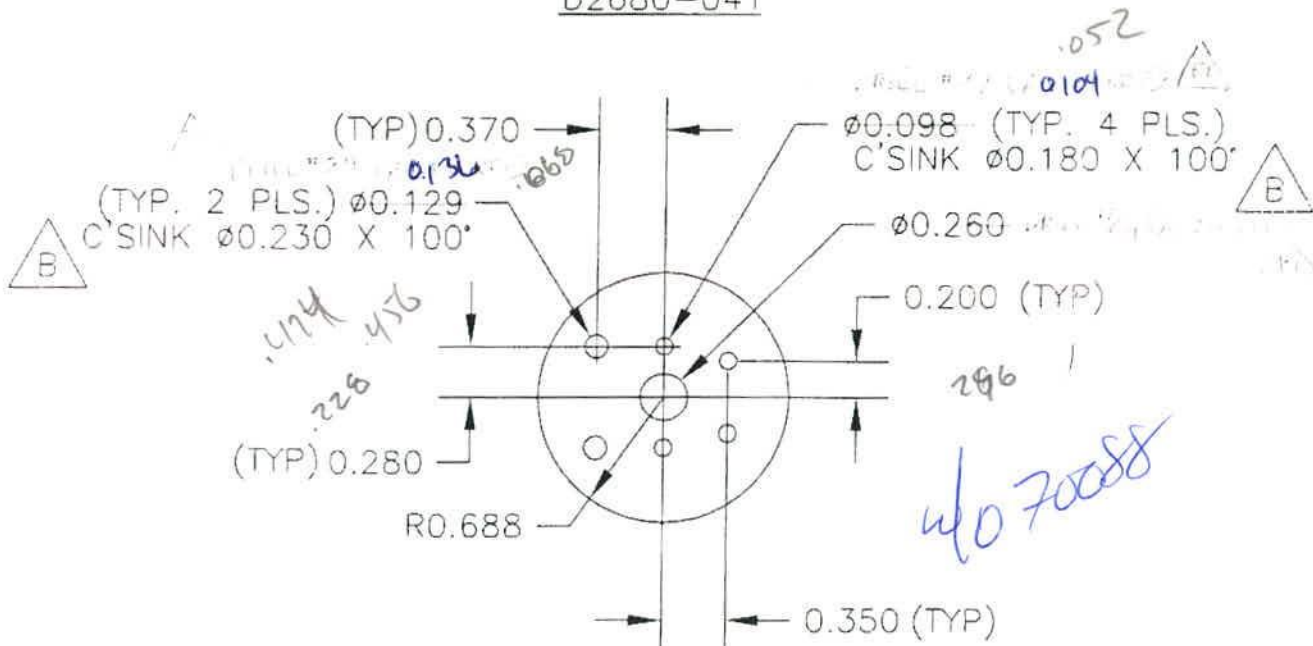
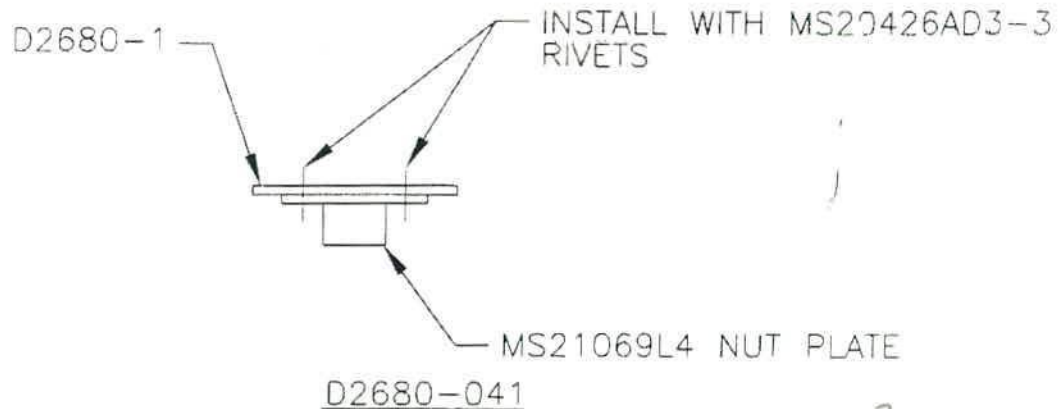
21 11/05/27

DART



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14		TITLE NUT PLATE	SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	

RELEASED
8-2-17



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2680-1

